

Monday, July 11, 2011 8:32:08 AM



Page 1

**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date: 11-07-24

### Tooling:

Date:

Run Start



**QC:**




Date:

**SPC (Y/N):**

**Date:**

**Stop**



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4017	C								
100		0.00							
									
Large Fab	<b>Memo</b>	0.00							
Large Fab	1- Cut tube as per dwg D4017 2- Debur and remove identify marks								
			SAD	11-07-15					
110	QC6- Inspect dimensions to drawing	0.00							
									
QC	<b>Memo</b>	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: WA	0.00							
									
Packaging	<b>Memo</b>	0.00							
Packaging									
			SAD	11-07-15					

**Work Order ID 71742**

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Item ID:	D4017-9	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib					
Start Date:	7/11/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	7/15/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/07/15

mk  
11-07-15

# Picklist Print

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Page 1

Work Order ID: 71742



Parent Item: D4017-9



Parent Item Name: Rib

Start Date: 7/11/2011

Required Date: 7/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as  
per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB  
DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18  
verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	736.7760	2.28166	14.41048			
Square Tubing													



SAD 11-07-15

Location

Loc Qty

Loc Code

MAT034

736.776

116610

0.8383

117721

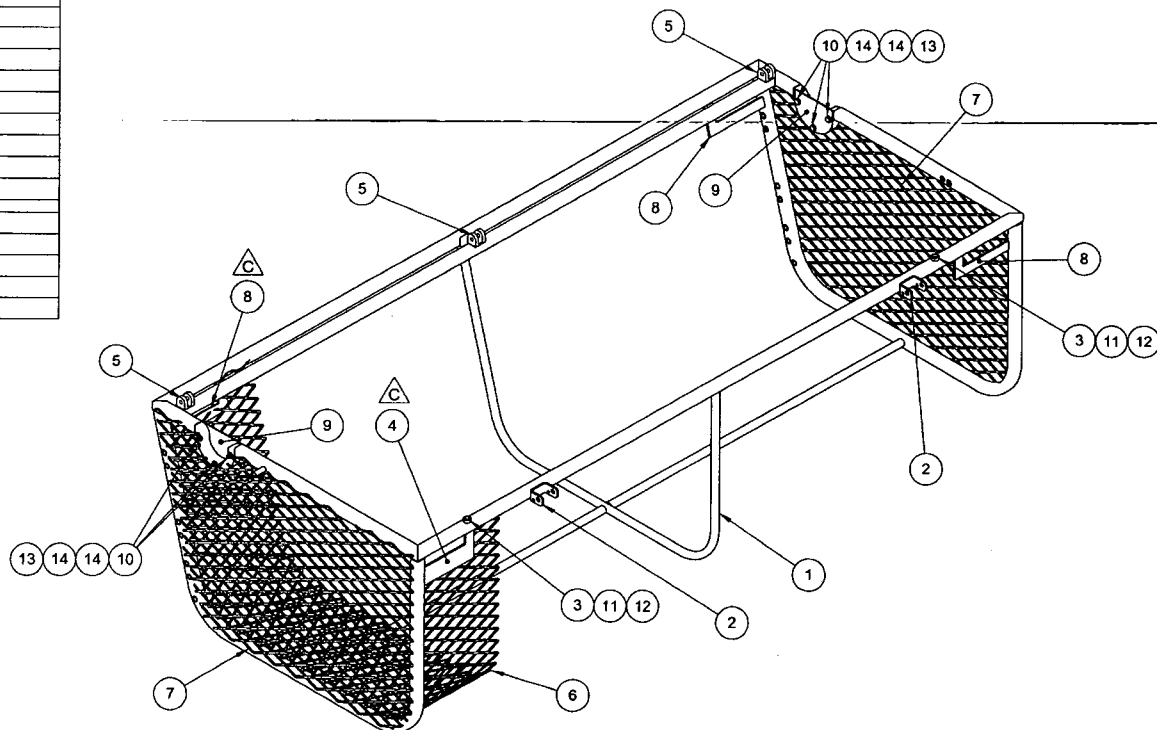
131.9377

117999

604

14.4105

ITEM	QTY .041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71742  
11-07-11

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596  
**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4017</b> REV. C SHEET 1 OF 5 TITLE <b>SHORT BASKET BASE ASSY (350) _NTS</b> SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	J.F.S.		
APPROVED	WJ		
DE APPR.	WJ		
DATE	10.07.23		

**DETAIL C** D5-2

TACK WELD MESH AT EVERY AVAILABLE LOCATION

**SECTION F-F** D5-2  
TYPICAL FOR ALL HANDLE PLATES

D4021-1 HANDLE PLATE

TACK WELD MESH AT EVERY AVAILABLE LOCATION

D6-2 F

F

C8-2 C

D4020-3 MESH

10.38

34.50

D4017-101 TUBULAR ASSY

D2931 BUMPER  
AN960JD8 WASHER  
MS20600AD4W3 RIVET  
2 PL [8]

D2581 MOUNTING BRACKET  
2 PL

2 PL

**DETAIL D**

D4020-11 END MESH

6 PL [9] A4-3

TACK WELD MESH AT EVERY AVAILABLE LOCATION

9

4 PL

TRIM MESH TO CLEAR BUSHING  
Ø0.75

0.38 TYP

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

D3913-15 WIDE HANDLE PLATE

0.75 2 PL

27.94

A

B6-3 A

D4016-1 HINGE HALF, BASE  
3 PL

D4021-1 HANDLE PLATE  
2 PL

B

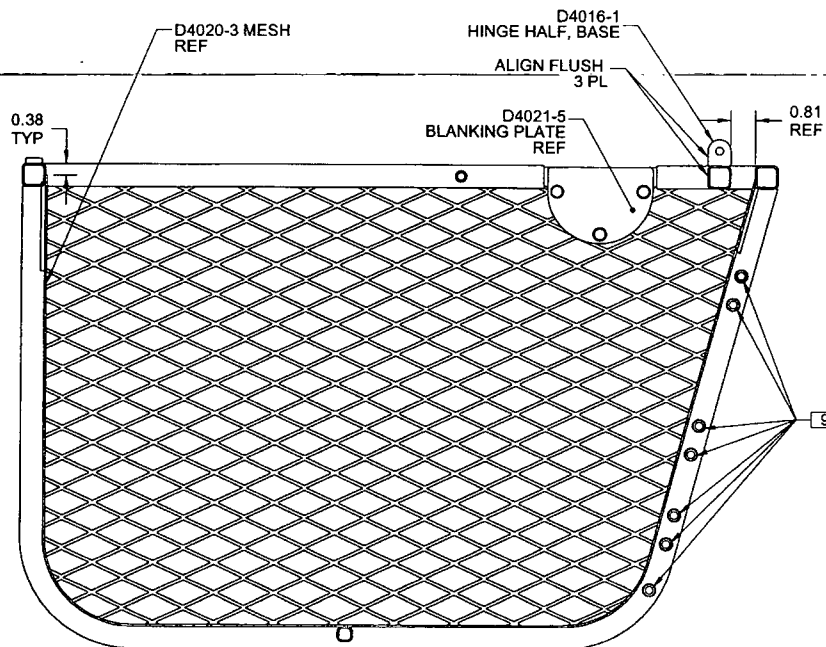
B2-3 B

3 PL

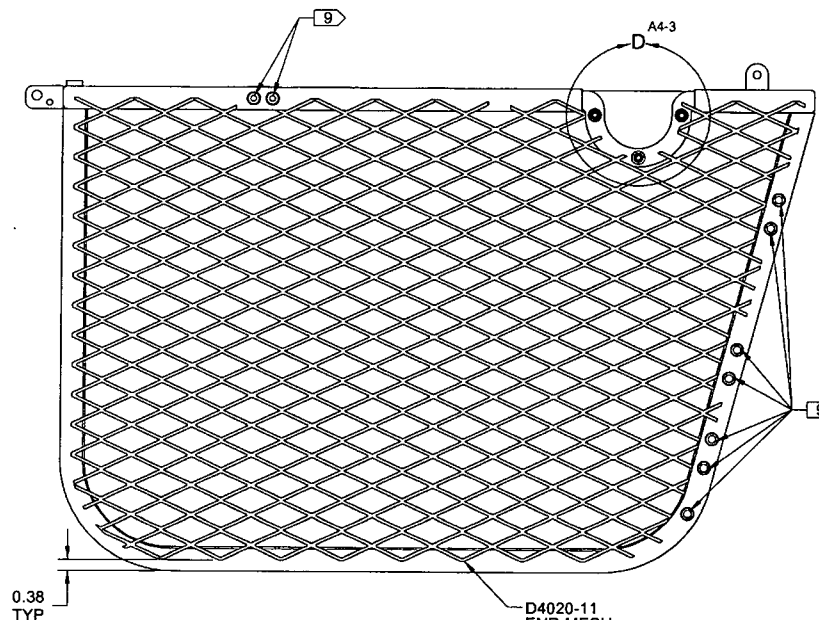
**RELEASED**  
10.08.17 9'

DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	UP	
CHECKED	JES	
MFG. APPR.	W	
APPROVED	W	
DE APPR.	W	<b>D4017</b>
DATE	10.07.23	<b>SHORT BASKET BASE ASSY (350)</b>
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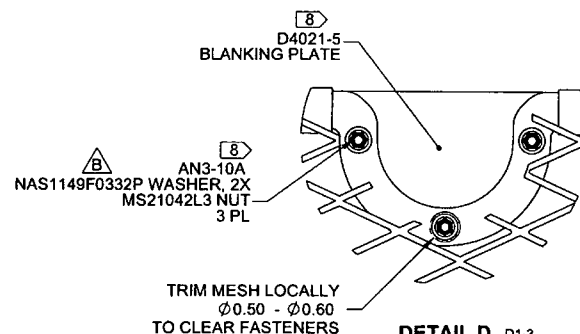
71742



**SECTION A-A** A2-2



**SECTION B-B** A2-2

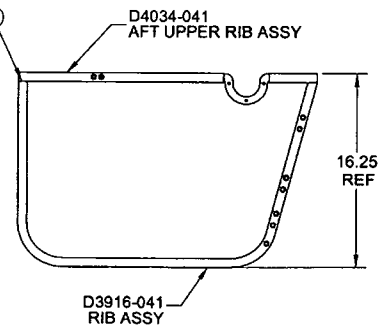
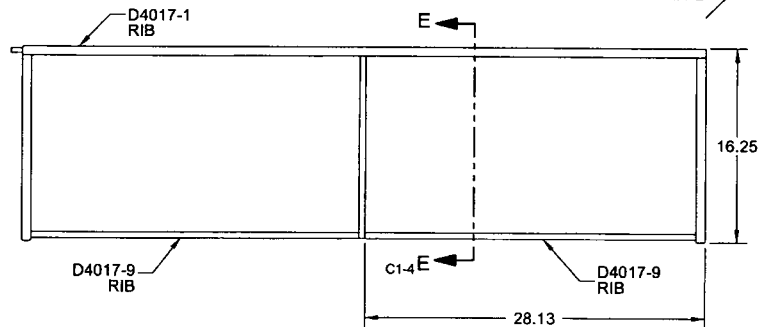
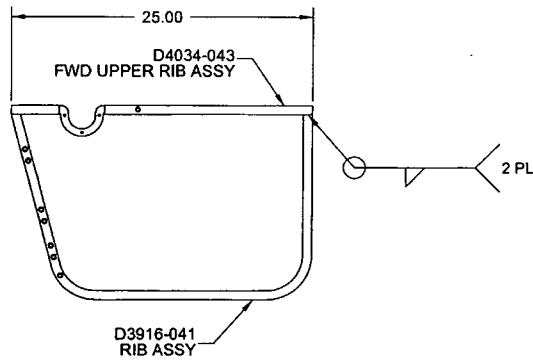
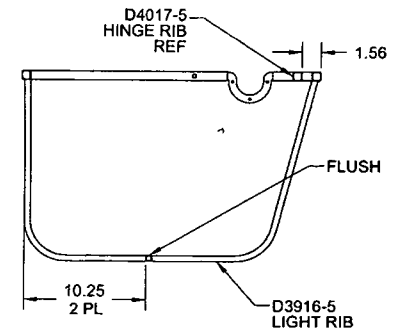
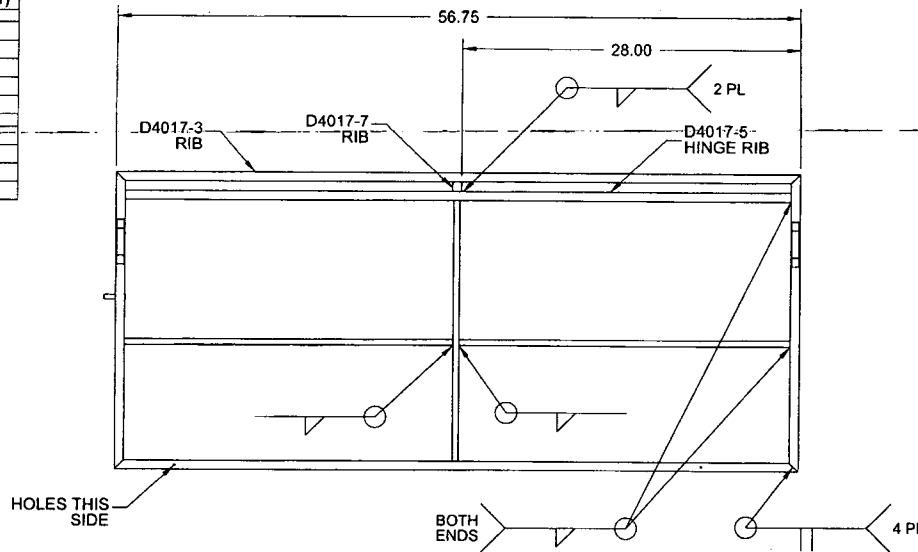


**DETAIL D** D1-3 B8-2

RELEASED  
10.08.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT-BASKET-BASE ASSY (350) - NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	REV. C
DRAWN	77	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4017	SHEET 4 OF 5
MFG. APPR.	SYS. B.S.L.	TITLE	SCALE
APPROVED	JM	SHORT BASKET-BASE ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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10.08.17

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